

Claims

1. A method of manufacturing a packaging material laminate of web form which comprises at least a printing ink outer layer, an aluminum vapor deposition film layer containing linear low density polyethylene obtained by a polymerization using metallocene catalyst, a polyethylene-extrusion lamination layer, and a carrier layer of paper or paper substitution material, according to following steps;

a step of vapor-depositing aluminum on one side of the web form film containing the linear low density polyethylene obtained by the polymerization using the metallocene catalyst,

a step of winding up temporarily the aluminium vapor deposition film containing the linear low density polyethylene obtained by the polymerization using the metallocene catalyst in a reel form, making direct contact between the aluminium vapor deposition surface and the film surface containing the linear low density polyethylene, and keeping the reel in predetermined time,

a step of unwinding the aluminium vapor deposition film from the kept reel, applying a fused lamination resin by extrusion lamination by fused polyethylene between the vapor deposition surface of an aluminium vapor deposition film layer and the surface of the carrier layer, and laminating the aluminium vapor deposition film layer and the carrier layer and,

a step of forming an ink layer in the external surface of the outside of the laminate by printing simultaneously, before and after the above-mentioned steps.

2. The method of manufacturing of packaging material laminate according to claim 1 wherein the carrier layer is laminated, without coating anchor-coat material in the carrier layer just before the step of laminating the aluminium vapor deposition film layer and the carrier layer.

3. A laminate for packaging material containing a printing ink layer, the 1st aluminium vapor deposition polyethylene layer obtained by vapor depositing aluminium to linear low density polyethylene obtained by a polymerization using metallocene catalyst, a carrier layer of paper or paper substitution material, and the 2nd aluminium vapor deposition polyethylene layer obtained by vapor depositing aluminium in linear low

density polyethylene obtained by a polymerization using metallocene catalyst and, being constituted in order of the laminating, characterized by that

the printing ink layer is laminated to the polyethylene layer side of the 1st aluminium vapor deposition polyethylene layer,

the carrier layer of paper or paper substitution material is laminated through a polyethylene-extrusion lamination layer to the aluminium vapor deposition layer side of the 1st aluminium vapor deposition polyethylene layer,

the carrier layer of paper or paper substitution material is laminated through a polyethylene-extrusion lamination layer to the aluminium vapor deposition layer side of the 2nd aluminium vapor deposition polyethylene layer.

4. A laminate for packaging material containing a printing ink layer, an aluminium vapor deposition polyethylene layer obtained by aluminium vapor deposit to linear low density polyethylene obtained by a polymerization using metallocene catalyst, a carrier layer of paper or paper substitution material, and a polyolefin inner layer and, being constituted in order of the lamination,

characterized by that

the printing ink layer is laminated to the polyethylene layer side of the aluminium vapor deposition polyethylene layer,

the carrier layer of paper or paper substitution material is laminated through a polyethylene-extrusion lamination layer to the aluminium vapor deposition layer side of the aluminium vapor deposition polyethylene layer.

5. A laminate for packaging material which comprises a printing ink layer, a polyolefin outer layer, a carrier layer of paper or paper substitution material, and an aluminium vapor deposition polyethylene layer obtained by aluminium vapor deposit to linear low density polyethylene obtained by polymerization using metallocene catalyst, and is constituted in order of the lamination,

characterized by that

the carrier layer of paper or paper substitution material is laminated through a polyethylene-extrusion lamination layer to the aluminium vapor deposition layer side of the aluminium vapor deposition polyethylene layer.

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6. Laminate for packaging material of any claim of Claims 3-5 wherein any anchor-coat material is not coated on the carrier layer surface in the lamination structure between the aluminium vapor deposition film layer and the carrier layer.

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